

Work Order ID 134150

134150

Page 1

Friday, July 03, 2015 3:46:15 PM

Item ID: D4038-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle, Fwd, RH

Start Date: 7/03/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: JUL 06 2015

Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4038	E

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank 7.125" long

2

0

15/07/21

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg & Folio FA880

Dwg Rev: E

Folio Rev: AT

Deburr

2

0

15/07/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																								
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Friday, July 03, 2015 3:46:15 PM

Item ID: D4038-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle, Fwd, RH

Start Date: 7/03/15 **Start Qty:** 1:00 ***1***

Cust Item ID:

Required Date: 7/03/15 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 134150

134150

Page 3

Friday, July 03, 2015 3:46:15 PM

Item ID: D4038-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle, Fwd, RH
 Start Date: 7/03/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/03/15 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							DAS 38 9-89
150						(2)			JUL 2 2 2015
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>S 244</u>	0.00			DAS 30 9-89		2		JUL 2 3 2015
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									
						MLJ			JUL 2 3 2015
						SH			JUL 2 3 2015
						15/7/23			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Friday, July 03, 2015 3:46:15 PM

Work Order ID: 134150

134150

Parent Item: D4038-2

D4038-2

Parent Item Name: Angle, Fwd, RH

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 1.00

Required Qty: 1.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A4.000W.250		Purchased		No		100	f	51.0000	0.7	1			

M6061T6A4 000W 250

6061T6 ANGLE 4.00 x 4.00 x .250

Handwritten signature
15/07/21

Location

Loc Qty

Loc Code

MAT028

51

m118106

31

m128265

20

1,796

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 134150	
Description: Angle, Fwd, RH		Part Number: D4038-2	
Inspection Dwg: D4038 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.997	✓		MIP-04	vern
3.45	+/-0.030	3.455	✓		...	...
R0.25	+/-0.030	0.250	✓		—	Radius gauge
0.250	+/-0.010	0.247	✓		MIP-04	vern
1.25	+/-0.030	1.245	✓		↓	↓
1.25	+/-0.030	1.245	✓			
2.877	+/-0.010	2.877	✓		31006	Height gauge
0.581	+/-0.010	0.582	✓			
0.669	+/-0.010	0.669	✓			
0.706	+/-0.010	0.706	✓			
0.500	+/-0.010	0.500	✓			
2.00	+/-0.030	2.000	✓		MIP-04	vern
0.563	+/-0.010	0.563	✓		31006	Height gauge
Ø0.316	+0.006/-0.001	0.319	✓		MIP-04	vern
Ø0.189	+0.005/-0.001	0.191	✓		...	...
R0.13	+/-0.030	0.125	✓		—	Radius gauge
1.00	+/-0.030	1.000	✓		MIP-04	vern
1.063	+/-0.010	1.063	✓		31006	Height gauge
1.563	+/-0.010	1.560	✓		MIP-04	vern
1.19	+/-0.030	1.190	✓		↓	↓
1.00	+/-0.030	1.00	✓			
2.125	+/-0.010	2.125	✓			
0.911	+/-0.010	0.911	✓		↓	↓
R0.13	+/-0.030	0.125	✓		—	Radius gauge
0.882	+/-0.010	0.879	✓		MIP-04	vern
1.750	+/-0.010	1.750	✓		...	...
7.00	+/-0.030	7.000	✓		31006	Height gauge
0.50	+/-0.030	0.497	✓		MIP-04	vern

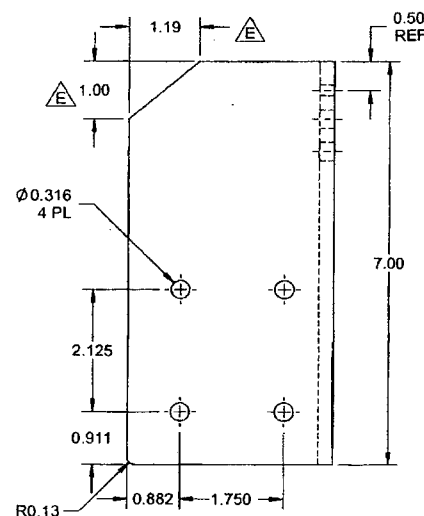
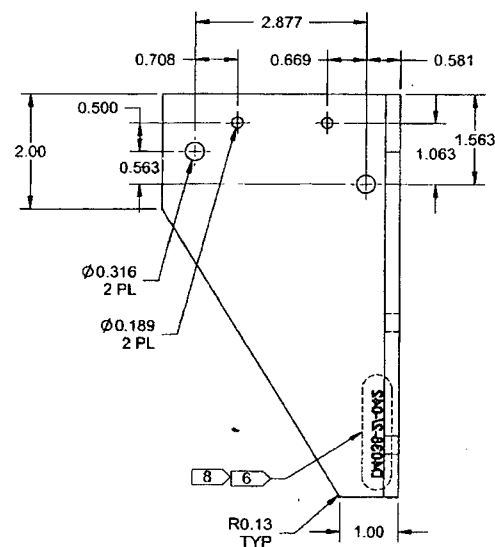
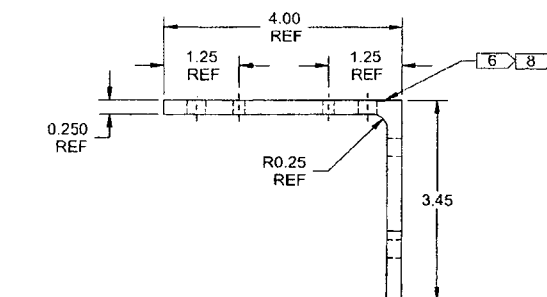
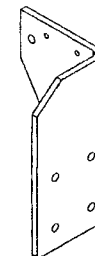
Measured by: <i>[Signature]</i>
Date: 15/07/22

Audited by: LA	DAS
Date: 15/07/22	06 9-89

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dwg Rev updated	KJ	
C	11.06.21	Dwg Rev updated	KJ	<i>[Signature]</i>

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1507-06



D4038-2 ANGLE, FWD, RH

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM, ANGLE, 4.000 X 4.000 X 0.250
PER AMS-QQ-A-200/8
REF DART SPEC M6061T6A4.000XW250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN (FAR SIDE ONLY) TO MAX
DEPTH OF 0.010 IN 0.18 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 1.03 lbs
- 8) SPOT FACE MAX DEPTH OF 0.010 PRIOR TO MARKING

RELEASED
2011-04-22
JMD

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D4038	REV. E SHEET 4 OF 14
CHECKED		TITLE BRACKET	SCALE NTS
MFG. APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE FIDELITY CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED		DATE 11.04.11	
DE APPR.			